

Date: Friday, 20/02/2009 9:11:36 AM
 User: Jean-Luc Menard

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number :	45921		
Estimate Number :	10530		
P.O. Number :		Part Number :	D2571
This Issue :	20/02/2009	Drawing Number :	D2571 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	E
Previous Run :	43564	Material :	
Written By :	<u>JLM 09.02.20</u>	Due Date :	27/02/2009
Checked & Approved By :		Qty:	12
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: B42991

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. B45921 Double check by: JTP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ571 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: AD Date: 09/03/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: AD Date: 09/03/03

NCR: <u>45921</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.02.25	2	Thickness under tolerance on one side, over tol on other (0.110/0.145)	<u>UP</u> 09.02.25 pr QSI 042	SCRAP PART. Mach Misalignment between holes and bore likely to cause fit problem.	<u>SV</u> 09/02/26	<u>S</u> 09.02.26	<u>UP</u> 09.02.25 pr QSI 042	<u>S</u> 09.02.26

NOTE: Date & initial all entries

Date: Friday, 20/02/2009 9:11:37 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 45921

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/02/26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 09-02-26

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

FL 09/03/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-02

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 733

g/k

X 11
IN
SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



MF
09-03-02

DART AEROSPACE LTD	Work Order: 45921
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.375	.376	.376	.376		
I	0.490	0.510		.495	.503	.500	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.562	.570	.568	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.130	.129	.130	.130		
Q	0.115	0.135		.135	.126	.135	.135		
R	0.240	0.260		.256	.253	.250	.248		
S	0.115	0.135		.135	.126	.128	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.961	2.961		
V	0.230	0.250		.245	.243	.242	.240		
W	0.115	0.135		.135	.128	.130	.127		
X	0.308	0.313		.313	.313	.313	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.369	.369	.369	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.388	1.388		
AF	0.115	0.135		.124	.124	.124	.124		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 88
Date: 09/02/21

Audited by: J.L
Date: 09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	4592/
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	SCFAP		
A	0.438	0.443		.438	.438	.438			
B	1.745	1.755		1.750	1.746	1.746			
C	3.495	3.505		3.500	3.496	3.497			
D	1.745	1.755		1.750	1.745	1.746			
E	7.990	8.010		8.000	8.000	8.000			
F	0.490	0.510		.500	.504	.493			
G	0.257	0.262		.259	.259	.259			
H	0.375	0.380		.376	.376	.376			
I	0.490	0.510		.502	.500	.503			
J	1.174	1.184		1.179	1.179	1.179			
K	0.558	0.578		.571	.570	.570			
L	1.174	1.184		1.179	1.179	1.179			
M	1.490	1.500		1.500	1.500	1.500			
N	2.495	2.505		2.500	2.500	2.500			
O	3.869	3.879		3.874	3.873	3.873			
P	0.115	0.135		.131	.126	.128			
Q	0.115	0.135		.130	.130	.130			
R	0.240	0.260		.254	.253	.254			
S	0.115	0.135		.123	.123	.119			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.960	2.963	2.963			
V	0.230	0.250		.246	.240	.245			
W	0.115	0.135		.127	.127	.129			
X	0.308	0.313		.312	.312	.313			
Y	0.760	0.765		.760	.760	.761			
Z	0.352	0.372		.363	.362	.363			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.630	.629	.629			
AC	0.053	0.073		.063	.060	.063			
AD	0.240	0.260		.250	.250	.250			
AE	1.375	1.395		1.388	1.380	1.380			
AF	0.115	0.135		.125	.125	.125			
AG	0.240	0.280		.260	.260	.260			
AH	0.240	0.260		.257	.257	.257			
AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

Measured by:	DS / mwf
Date:	09/02/23 / 09/02/24

Audited by:	J.L
Date:	09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 4592/
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.438	0.443		.440	.440	.439	.439		
B	1.745	1.755		1.747	1.747	1.747	1.746		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.509	.490	.491	.491		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.376	.376	.375		
I	0.490	0.510		.504	.502	.502	.503		
J	1.174	1.184		1.180	1.178	1.177	1.178		
K	0.558	0.578		.572	.573	.573	.573		
L	1.174	1.184		1.177	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.495		
N	2.495	2.505		2.499	2.504	2.504	2.505		
O	3.869	3.879		3.871	3.872	3.872	3.872		
P	0.115	0.135		.131	.130	.131	.130		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.254	.254	.253	.253		
S	0.115	0.135		.126	.125	.124	.125		
T	0.178	0.198		.188	.187	.187	.187		
U	2.940	2.980		2.959	2.960	2.958	2.959		
V	0.230	0.250		.249	.242	.242	.241		
W	0.115	0.135		.122	.116	.116	.115		
X	0.308	0.313		.312	.313	.312	.312		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.634	.635	.634	.634		
AC	0.053	0.073		.062	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.133	.130	.130	.131		
AG	0.240	0.280		.251	.262	.263	.250		
AH	0.240	0.260		.258	.254	.249	.253		
AI	2.000	2.020		2.000	2.000	1.998	1.999		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									






Measured by: <i>mwr</i>
Date: 09/02/25

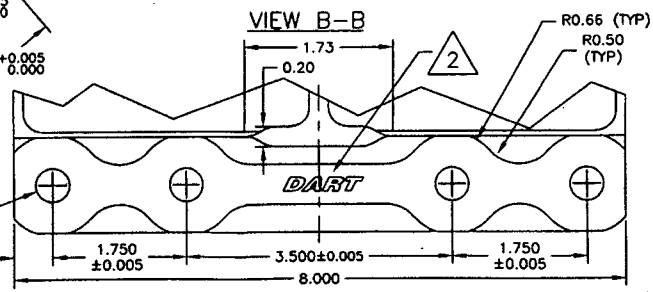
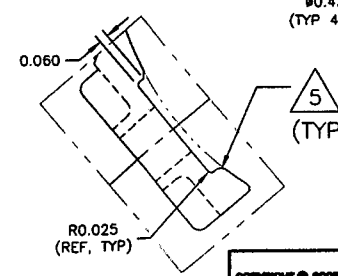
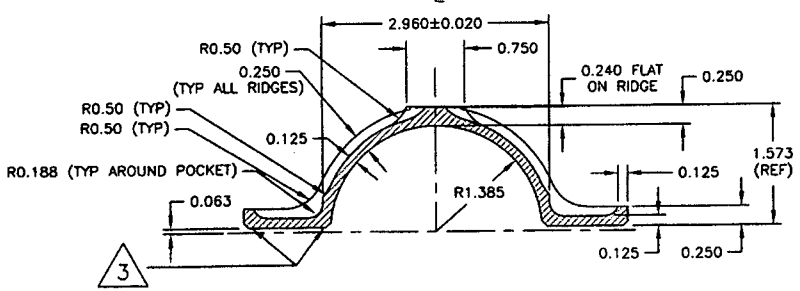
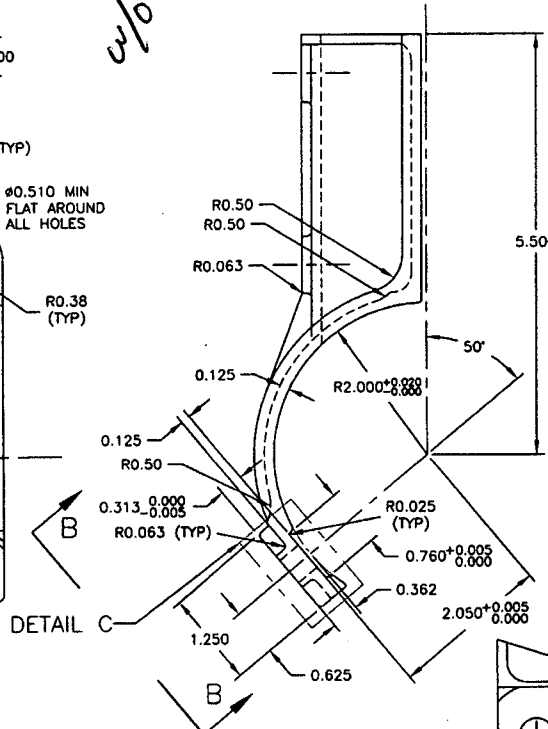
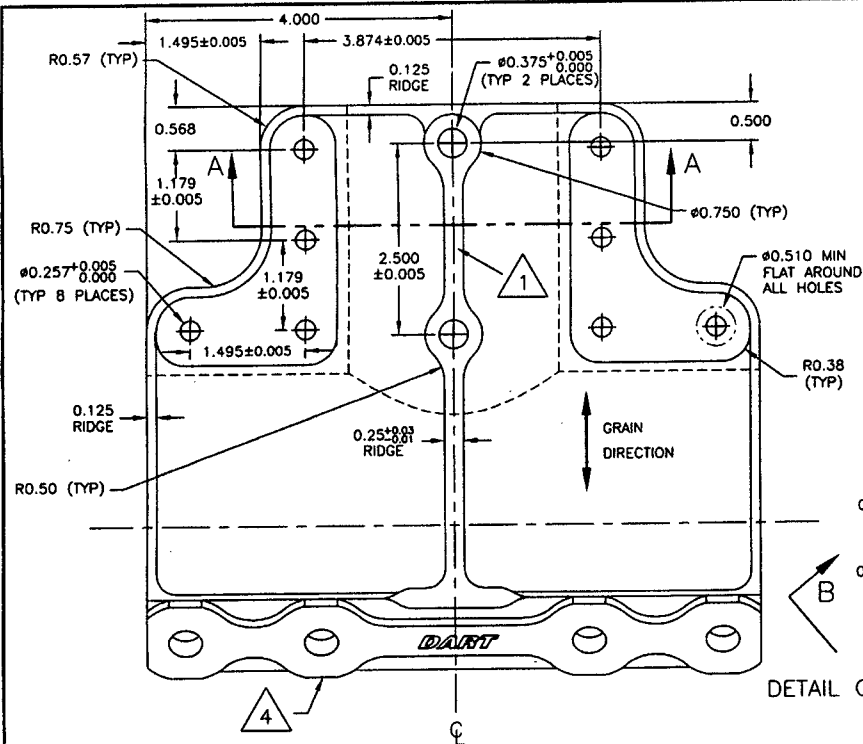
Audited by: <i>J.L</i>
Date: 09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

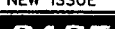


MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1.
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



SECTION A-A

DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 6
		D2571	SHEET 1 OF 1
DATE		TITLE	
05.07.13		OUTER FWD SADDLE	
		SCALE	
		2:3	